

Work Order ID 83523

83523

Page 1

Thursday, April 19, 2012 10:29:10 AM

Item ID: D3719-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate

Start Date: 4/19/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

1205-19

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3719

Rev A

100

0.00

100

Waterjet

FLOW WATERJET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3719

Dwg Rev: A

Prog Rev: A

2-

Deburr if necessary

304 . 063

B12-5-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-19

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Scrap

78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 4/27/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab	Large Fab	0.00				8			12-06-04 JBL
	Memo	0.00							
	1-Weld D3009-3 cups as per dwg D37192-Weld hard facing as per Dwg D3719 A/R 2059B Hard Coat rod Batch: m114509								
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00				8x	Ø		
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							Sealed

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N900040100

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Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 10:45	0.00							
	FINISH TIME: 11:45								
	OVEN TEMPERATURE: 3200F								
170	QC3- Inspect Part Finish	0.00							
170									
QC									
Quality Control									
	Memo								
180	Identify as per dwg & Stock Location 501	0.00							
180									
Packaging									
Packaging									
	Memo								

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Required Date: 4/27/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

ME
12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 1

Thursday, April 19, 2012 10:29:13 AM

Work Order ID: 83523

83523

Parent Item: D3719-041

D3719-041

Parent Item Name: Wearplate

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 07-12-19 EC verified by DD
IPP Rev:B 08-09-25 add QC5 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3009-3		Manufactured	No			100	Each	32.0000	4	24			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3009-3

Cup

**

12-05-31
JBL

Location

Loc Qty

Loc Code

WA

83174 X 32

32

32

79078

30

80095

2

M304S16GA

Purchased

No

130

sf

161.5720

0.565

3.568421

7.

M304S16GA

**

12-5-12

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

161.572

120866

24.246

120877

137.326

121626

121626

8

W/O:		WORK ORDER CHANGES					
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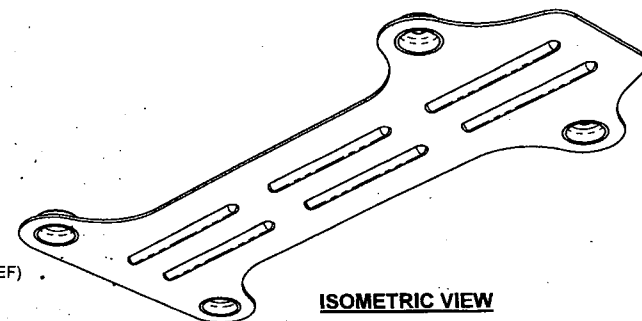
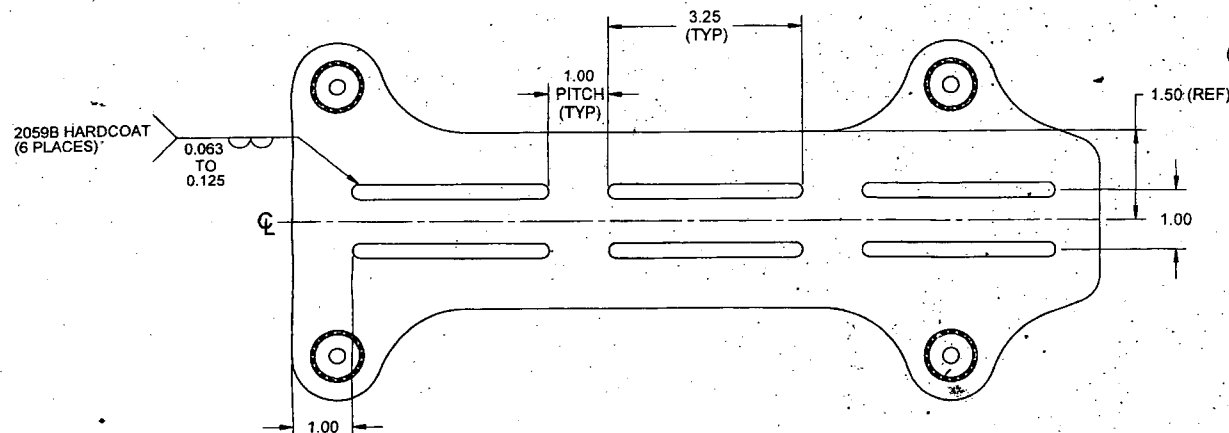
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PARTS LIST FOR D3719-041 WEARPLATE:		
QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP

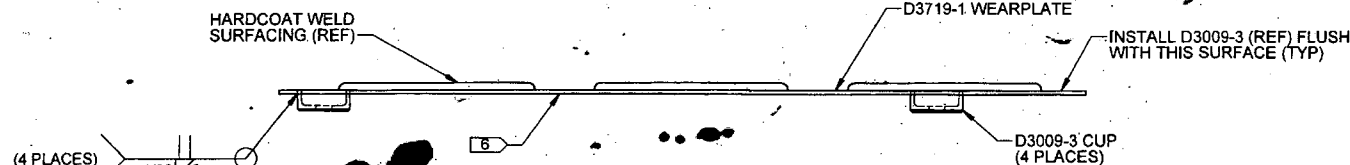


ISOMETRIC VIEW

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83523


112-04-19

RELEASED
07-01-07



D3719-041 WEARPLATE

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE
 - 9) WELD PER DART QSI 004

A		NEW ISSUE		CP	07.12.12
REV.	DESCRIPTION			BY	DATE
DESIGN	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN					
CHECKED				DRAWING NO.	REV.
MFG. APPR.				D3719	SHEET 1 OF
APPROVED				TITLE	SCALE
DE APPR.				WEARPLATE	1:
DATE	07.12.12			COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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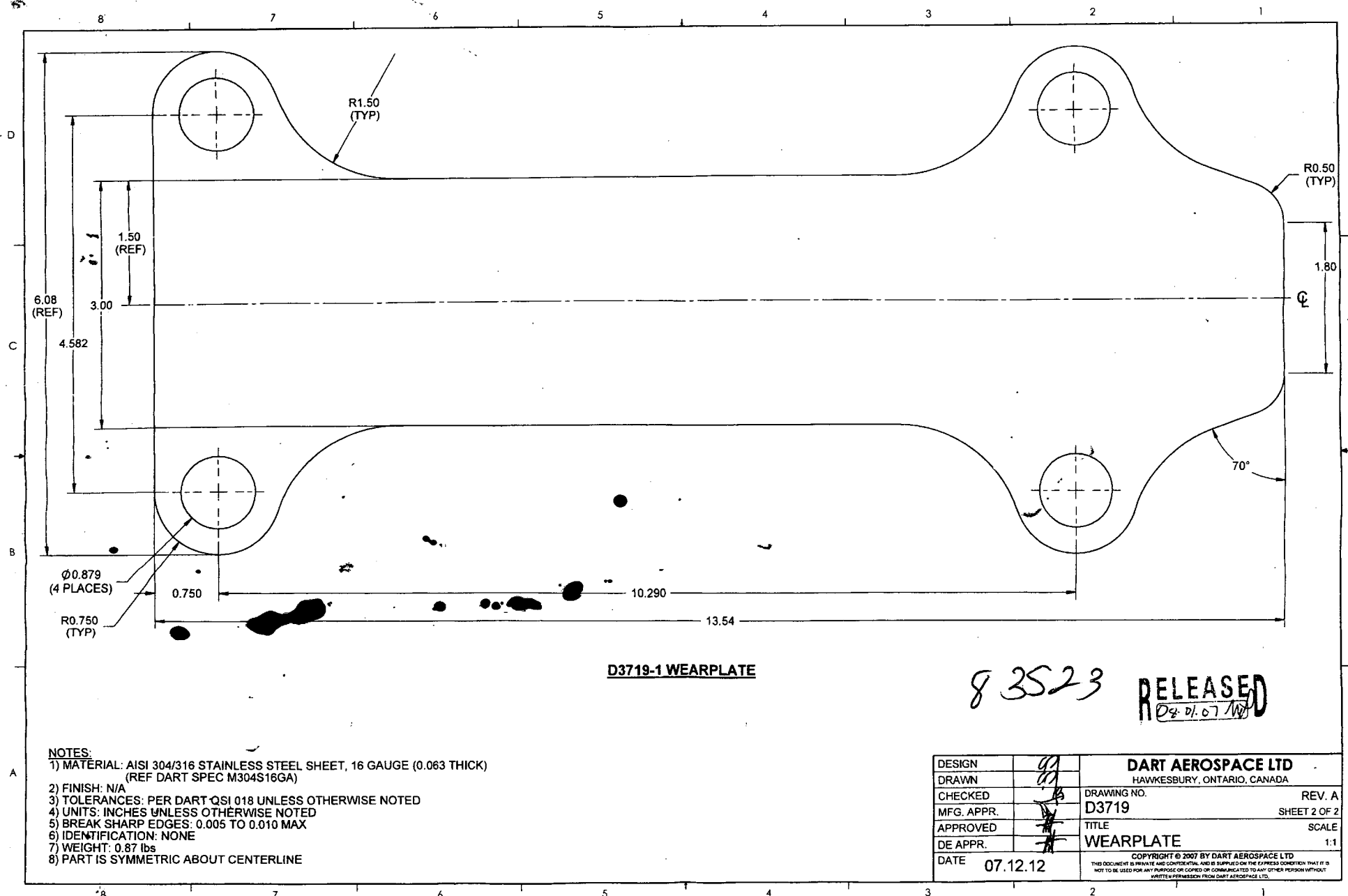
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